



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5621-041
Job Sheet 198174



Part No: D5621-041

Job Qty: 1 pcs

Part Name: Skylight Window Assembly, LH Clear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/23/19

Job Tracking No:

Due Date: 9/20/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: D5621 REV.C IPP REV:A 18.05.22 NEW ISSUE DD VERF:JFS IPP REV:B 18.09.04 AS PER DWG REV.B DD VERF:JFS IPP REV:C 19.01.14 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time		
100	Purchasing	1 pcs		9/20/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	1 pcs		9/20/19	0.00	1.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S219600



Part: D5621-041

Job No: 198174

Serial No/Batch: S219600

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/03/19

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	1 pcs	9/20/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	81
					QC 6 - 81	9-89
						OCT 04 2019
130 Packaging 3-1 - Stock - B4B	1 pcs	9/20/19	0.00 1.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	9/20/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Issue P/O: _____ Supplier: Llamas Manufacture D5621-041 as per Dwg Notes. C of C is required.
 Descriptions: ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOWS***

110 - (Receive & Inspect for Damage & Mat'l Certs) C of C is required. ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOWS***

120 - (QC6- All purchased or subcontracted products) ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOWS***

130 - (Identify as per dwg & Stock Location: _____) ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE

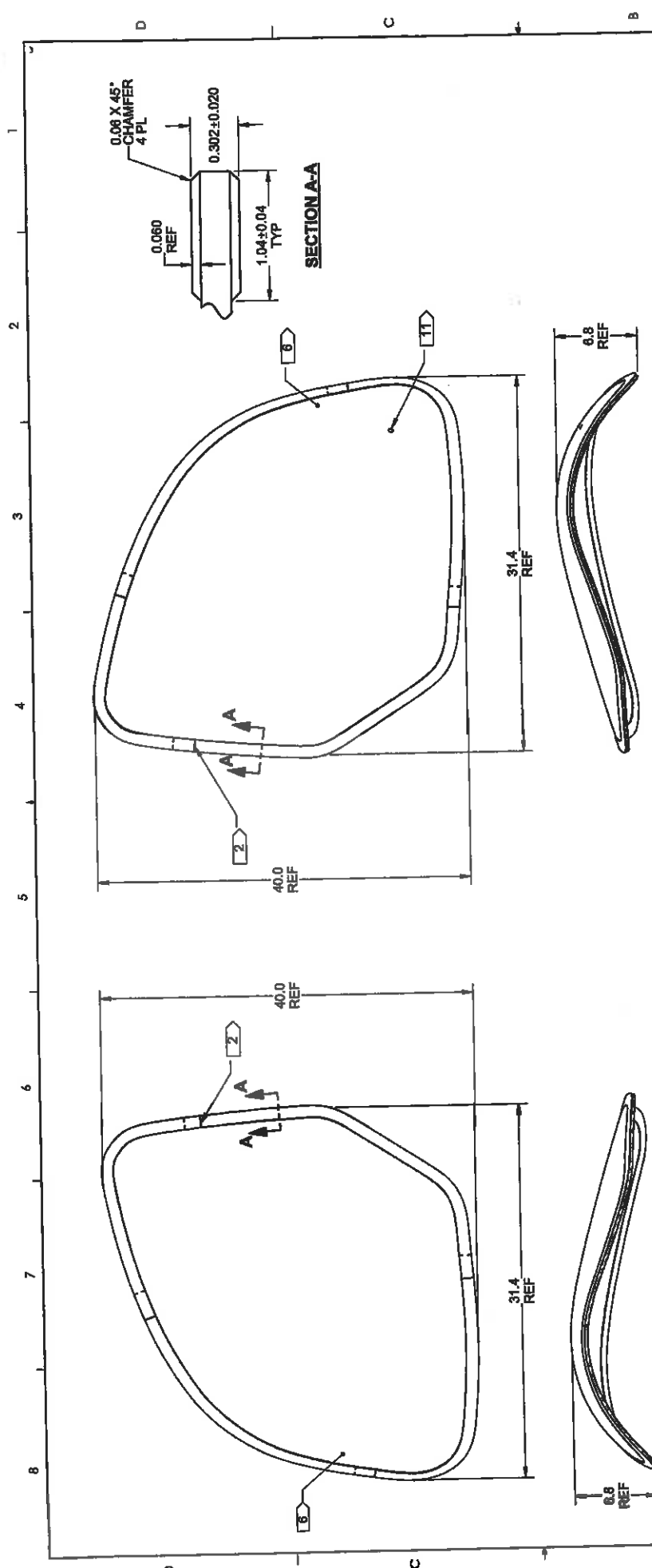
7/23/2019

[Dart Hawkesbury] Job Sheet - Lavoie, Chantal

SURFACE OF THE WINDOWS***
140 - QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5621-041P	Skylight Window Assembly, LH Clear	1 Ea (1 ea)	100-Purchasing	5219598
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D5621-041P	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 7/23/19 11:45 AM Dart.Lavoie.Chantal



D5621-042-044 SKYLIGHT WINDOW, RH

D5621-041-043 SKYLIGHT WINDOW, LH

NOTES:

- 1) MATERIAL: -041-042: MAKROLON TUFFAK UC/GP, CLEAR, 0.177" THICK
-043-044: MAKROLON TUFFAK CP, BRONZE #5109, 0.187" THICK
- 2) FINISH: APPLY LPI AEROCOAT 1077 HARD COAT (BOTH SIDES)
INSTALL LPI 9148 EDGE ATTACHMENT USING PR1425 PER "D5621-041 CF" (LH) OR "D5621-042 CF" (RH)
IT IS ACCEPTABLE TO SPlice EDGE ATTACHMENT BETWEEN HOLES.
INNER AND OUTER SPLICES MUST BE AT LEAST ONE HOLE SPACING APART
- 3) TOLERANCES: PER DART GSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: ALL TRIMMED SURFACES MUST HAVE FINISH
- 6) IDENTIFICATION: SANDBLAST IDENTIFICATION USING 0.125" LETTERS IN LOCATION SHOWN (MAX 0.005" DEEP):
D5621-04X (P/N) SN XXX (S/N)
XX-20YY (DATE) 3AL64 (CAGE CODE)
- 7) WEIGHT: 6.40 - 7.25 LBS
- 8) FORM PER LPI PROCESS "D5621" USING LPI FORMING TOOL "D5621-041 FM" (LH) OR "D5621-042 FM" (RH) RESPECTIVELY
- 9) TRIM PER LPI TRIMMING TOOL "D5621-041 TF" (LH) OR "D5621-042 TF" (RH) RESPECTIVELY
- 10) EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOW
- 11) DRILL 0.375 HOLE ON -042-044 PER LPI TRIMMING TOOL "D5621-042 TF"
- 12) ACCEPTANCE CRITERIA:
A) MINIMUM THICKNESS AFTER FORMING IS 0.150"
B) CONTOUR: MUST FIT FORMING TOOLS WITH A MAX GAP OF 0.080" AT THE TRIM LINE WHEN NO MORE THAN 4X ALL WEIGHTS ARE EQUALLY SPACED ON THE PERIMETER
C) DISTORTION: INSPECTOR TO VIEW THRU PART. NO MORE THAN 3X 0.080" DEFECTS IN A CIRCLE WITH A 6.77" RADIUS.
WINDOW MUST BE GENERALLY PARALLEL EXCEPT FOR WITHIN 1" OF THE WINDOW PERIMETER, WHICH IS NON-OPTICAL

RELEASED
2019 JAN 11
E.O. 11-24

REV.	DESCRIPTION	BY	DATE
C	REVISED NOTE 1	VS	19.07.07
B	ADDED 0.005" RADIUS PERIMETER FOR INCREASED EDGE DISTANCE WHEN TRANSFER DRILLING	VS	18.07.25
A	NEW ISSUE	VS	18.02.21
DESIGN	DB	VS	
DRAWN	VS		
CHECKED	RF		
MFG. APPR.	RA		
APPROVED	VS		
DE APPR.	DS		
DATE	19.01.07		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D5621
REV. C	SHEET 1 OF 1
TITLE	SKYLIGHT WINDOW
SCALE	NTS
DATE	19.01.07

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044071



Supplier: LLA001-VU
Llamas Plastics Inc.
12970 Bradley Ave.
Sylmar, CA 91342 USA
Phone: 818-362-0371
Fax: 818-362-9780

PO No: POHB044071

PO Date: 7/22/19

Due Date: 9/20/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Ship To:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	198077	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed -		9/10/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
						X1		SEP 10 2019					DP
2	198078	D5621-042P			Skylight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed -		9/10/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
						X1		SEP 10 2019					DP
3	198079	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed -		9/10/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
						X2		SEP 10 2019					DP
4	198080	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed -		9/16/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
						X1		SEP 19 2019					DP

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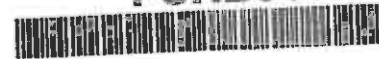


Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044071



Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
5	198081	D5621-042P			Skylight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed - X1		9/16/19 SEP 19 2018	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00 DP
6	198083	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed - X3		9/16/19 SEP 19 2018	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02 DP
7	198088	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed - X1		9/30/19 SEP 26 2018	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00 DP
8	198089	D5621-042P			Skylight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed - X1		9/30/19 SEP 26 2019	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00 DP
9	198090	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed - X2		9/30/19 SEP 26 2018	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02 DP
10	198174	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed - X1		10/14/19 OCT 03 2019	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00 DP
11	198175	D5621-042P			Skylight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed - X1		10/14/19 OCT 03 2019	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00 DP

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PURCHASE ORDER

POHB044071



Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
12	198176	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed	-	10/14/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
Grand Total:													\$17,968.08

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 9/9/19 1:25 PM Dart.Lavoie.Chantal

LLAMAS PLASTICS, INC.12970 Bradley Avenue
Sylmar, CA 91342-3829

818-362-0371 Fax # 818-362-9780

Packing Slip

Date	Invoice #
9/20/2019	L45330

Bill To

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON, K6A 1K7
CANADA

Ship To

LAVOICE CHANTAL
PHONE: 613-623-5200
EXT. 242
FAX 613-632-1053
CLAVOICE@DARTAERO.COM

P.O. Number		Rep	Via	F.O.B.
POHB044071			CALL FO...	Sylmar, CA
Quantity	Line Item	Description		
1	10	P/N: D5621-041P SKYLIGHT WINDOW ASSY LH CLEAR REV. C S/N: 009		
1	12	P/N: D5674-1P 5/16" DRILL BIT REV. A COUNTRY OF THE ORIGIN: USA CURRENCY: US DOLLARS \$ RECEIVED OCT 01 2019 DART AEROSPACE LTD. CERTIFICATION OF COMPLIANCE ATTACHED 9/20/19		



LLAMAS PLASTICS INC.

12970 BRADLEY AVE.
SYLMAR, CA 91342
(818) 362-0371
Fax (818) 362-9780

DATE: 9/20/19

CERTIFICATION OF COMPLIANCE

TO: **Dart Aerospace**

RE: **Contract/Purchase Order No (s): POHB044071**

Line Item #: **10 & 12**

Shipper No(s): **L45330**

Part No(s): **D5621-041P SKYLIGHT WINDOW ASSY LH CLEAR
REV. C
D5674-1P 5/16" DRILL BIT
REV. A**

Quantity: **1 EA.**

Serial No (S): **009**

Lot/Batch # (when applicable): **N/A**

DAS
81
9-89

This is to certify that the material and/or processes used to fabricate the above part number, comply with the specifications, drawings and other requirements of the contract or purchase order indicated.

The required reports and other certificates covering all material in the parts listed above, are on file and available for examination upon request.

Llamas Plastics, Inc.



Quality Rep